

154782

Wednesday, December 21, 2016 11:55:02 A

N900040100

Setup Start *NS1*

Stop *NS2*

Customer:

10

10

Run Start *NR1*

DAS
21
9-89

~~DEC 21 2016~~

Date:

Stop ***NR2***

Date:

Date:

**Insp.
Stamp**

Rev E

100

Waterjet

Memo

1.17

1-Cut as per Dwg D3407

Dwg Rev: E

Prog Rev: 5

2-Break edges on manual lathe Dwg D3407 (175rpm)

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.03

10

02/12/22

10

22/12/22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐		Mislabeled ☐		Finish ☐															
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐		Fit/Function ☐		Misread ☐															
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐		Misaligned/off center ☐		Turning Sequence ☐															
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____																					
Misidentified ☐		Past Due ☐																							

Work Order ID 154782

Wednesday, December 21, 2016 11:55:02 A

154782

Page 2

Item ID: D3407-5

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Ring

Start Date: 12/15/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 12/21/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
115	Manufacture as per dwg	0.00							DAS 32 9-89
115						10	0		
Lathe Conv	Memo	0.08							16-12-23
Conventional Lathe									
120	QC8- Inspect parts - second check	0.00							DAS 44 9-89
120						10	0		16-12-23
QC	Memo	0.03							
Quality Control									
130	Identify as per dwg & Stock Location: <u>WA002</u>	0.00							
130						10			17-01-09
Packaging	Memo	0.17							
Packaging	*****STOCK IN LARGE FAB***** LOCATION: WA002								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Revision ID:

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Item Name: Ring

Start Date: 12/15/2016 Start Qty: 10.00

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Cust Item ID:

Required Date: 12/21/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC21- Final Inspection - Work Order Release	0.00							
140							DAS 21 9-89	JAN 10 2017	
QC	Memo	0.02							
Quality Control									

DAS
21
9-89 JAN 10 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

Wednesday, December 21, 2016 11:55:02 AM

Page 1 / 1

Work Order ID: 154782

154782

Parent Item: D3407-5

D3407-5

Parent Item Name: Ring

Start Date: 12/15/2016

Required Date: 12/21/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 05-11-22 JLM
IPP Rev:B Now on Waterjet 08-05-14 JLM Verified By:DD
IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174B0.250X4.000		Purchased		No		100	f	21.8000	0.2666	2.806316			

M174B0 250X4 000

17-4 SS Bar .250 X 4.00

**

Dec 16/12/22

Location

Loc Qty

Loc Code

MAT051

21.8

m127866

9.8

m136304

12

2.8

DQA: _____ Date: _____



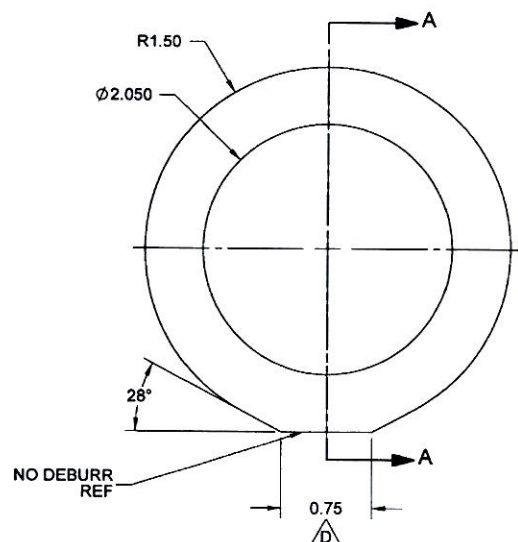
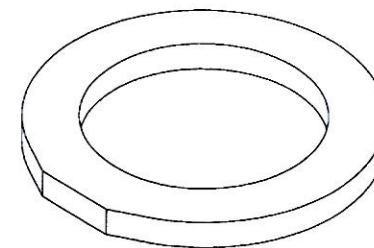
WORK ORDER NON-CONFORMANCE / UPDATE

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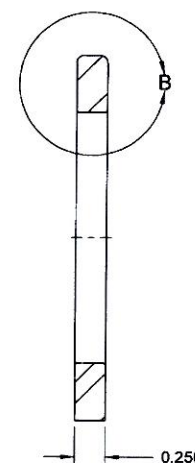
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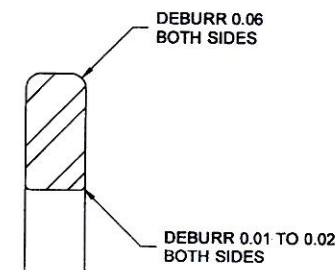
SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 154782MJS
16-12-21



D3407-5 RING



SECTION A-A



DETAIL B
 SCALE 2X

RELEASED
 08-08-21

- NOTES:
 1) MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643 (REF. DART SPEC M17-4-B)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.27 lbs

DESIGN	92	DART AEROSPACE USA, INC.	
DRAWN	1/8	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
DATE	08.07.23	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	